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DART AEROSPACE LTD		Work Order:	21584
Description: Bearpaw Kit (48" x 19") 205/430		Part Number:	K10015
Dwg: D2521 Rev. H		Qty:	15 Kits
Ref: K10015 Rev. A; DSK086-6 Rev. A		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																										
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required	JL	04.09.23	15																																										
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately)	JL	04.10.13	15																																										
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: M15926	JL	04/10/27	15																																										
4	MV	Inspect material for defects or damage prior to machining	JL	04/10/27	15																																										
5	MV	Machine as per Folio FA222 and Dwg D2521 Identify as D2521	JL	04/10/27	15																																										
6	QC2	Inspect parts as they come off the CNC machine	JL	04/10/27	15																																										
7	MV	Deburr	JL	04/11/02	15																																										
8	MV	Form as per Dwg D2521 using bending Jig DT8328	JL	04/11/02	15																																										
9	QC8 & 5	Second inspection	JL	04/11/05	15																																										
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>8</td> <td>D2182B055</td> <td>Rubber Cushion</td> <td>B21185</td> </tr> <tr> <td>16</td> <td>D2274</td> <td>Radius Block</td> <td>B21585</td> </tr> <tr> <td>2</td> <td>D2521</td> <td>Bearpaw</td> <td>B21584</td> </tr> <tr> <td>16</td> <td>D2529</td> <td>Washer B20964B</td> <td>B21587A</td> </tr> <tr> <td>8</td> <td>D2947</td> <td>Clamp B1420B/B1747/B19106</td> <td>B1483/B16839/B19991</td> </tr> <tr> <td>16</td> <td>AN4-15A</td> <td>Bolt</td> <td>M15321</td> </tr> <tr> <td>16</td> <td>AN960JD416</td> <td>Washer</td> <td>M15321</td> </tr> <tr> <td>16</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td>M15020</td> </tr> <tr> <td>1</td> <td colspan="3">Paperwork package from Step 2</td> <td></td><td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	B21185	16	D2274	Radius Block	B21585	2	D2521	Bearpaw	B21584	16	D2529	Washer B20964B	B21587A	8	D2947	Clamp B1420B/B1747/B19106	B1483/B16839/B19991	16	AN4-15A	Bolt	M15321	16	AN960JD416	Washer	M15321	16	MS21042L4	Nut (or -4)	M15020	1	Paperwork package from Step 2						04-11-02	15
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11	QC4	Inspect Kit for 100% Completeness on the W/O	JL	04/11/04	15																																										
12	PK	Identify and pack for shipping as per PPP K10015	JL	04/11/08	15																																										
13	AC	Cost / part 367,50	JL	04/11/09	15																																										
14	DC	Close W/O 371,82 Inspect Level 21	JL	04.11.10	15																																										

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	#

Brd 04-11-09

RELEASED
04.02.20 500

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
		Initial			Sign & Date			

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

DART AEROSPACE LTD	Work Order:	21584
Description: Bearpaw	Part Number:	D2521
Inspection Dwg: D2521	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	+/-0.030	1.007	✓		Vern	
B	+/-0.030	5.599	—		Vern	
C	+/-0.030	11.500	—			
D	+/-0.010	10.256	✓			
E	+/-0.010	13.256	✓			
F	+/-0.010	8.800	✓			
G	+/-0.030	22.125	—			
H	+/-0.010	8.756	—			
I	+/-0.030	44.500	✓			
J	+/-0.030	6.688	✓			
K	+/-0.030	5.625	✓			
L	+/-0.030	7.000	✓			
M	+/-0.010	5.000	✓			
N	+/-0.030	3.996	✓			
O	+/-0.030	6.625	—			
P	+/-0.030	19.000	✓			
Q	+/-0.030	0.318X45°	✓			
R	+/-0.030	0.196X45°	✓			
S	+/-0.030	0.510X45	✓			
T	+/-0.030	0.370X45	—			
U	+0.030/-0.010	0.063X45	—			
V	+0.005/-0.000	0.0260	✓			
W	+/-0.030	0.093	✓			
X	+0.030/-0.010	0.30	✓			
Y	+/-0.010	0.375	✓			
Z	+/-0.030	0.750	✓			
AA	+/-0.010	0.250	✓			
AB	+/-0.030	4.000	—			
AC	+/-0.030	6.625	—			
AD	+0.030/-0.010	0.950	✓			
AE	+/-0.010	0.375	✓			
AF	+/-0.030	3.399	—			
AG	+/-0.030	6.625	—			

Measured by:	<i>MF</i>	Audited by:	<i>EP</i>	Prototype Approval:	N/A
Date:	04/10/27	Date:	04/10/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/0 K10015	KJ/RF

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 23, 2004
10:35 am

Work Order No : 0021584
 Project Name : K10015
 Project For : WK444
 Work Order Type : Main
 Main WO Number :
 House Part Number : *K10015
 Description : Bearpaw Kit
 Manufactured : Yes
 Amount Req'd : 15
 Amount Done : 0
 Start Date : 09-23-04
 Est Finish Date : 10-30-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00